

Work Order ID 116371

116371

Page 1

Monday, April 14, 2014 9:29:47 AM

Item ID: D350-588-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Door Assembly
 Start Date: 4/14/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/6/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: CZ Date: 14/04/14 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	<u>JB</u>							
D2445/D350-588	Rev D/D								

100 Document Control 0.00
 100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D350-588-041 CHG003

DAS
06
2-89

JUN 17 2014

110 PURCHASING 0.00
 110 Purchasing 0.00
 Purchasing Memo
 Issue P/O: 23807
 Description: D2445 Baggage Door
 Supplier: Delastek
 Ship to Delastek (1) D0588-041 label
 Certification of Conformity and process sheet from Delastek is required.

CH751

CZ 14/04/15 (1)

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Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/6/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

IX SP14-6-2

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

Inspect as per Dwg D2445.
Audit process sheet.SPD
14/6/3

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Assemble all of the above parts as per Dwg D350-588

1 CR 14-06-03

Work Order ID 116371***116371***

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Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/6/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

Quality Control

0.00

155

Pick Kit

0.00

155

Packaging

Memo

Packaging

0.00

160

QC4- 100% Inspect kits for completeness

0.00

160

QC

Memo

Quality Control

0.00

DAS
31
9-89

IX

DAS
28
9-89DAS
33
9-89
14-06-03
JUN 17 2014

JUN 17 2014

Work Order ID 116371

Monday, April 14, 2014 9:29:47 AM

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Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/6/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
									JUN 7 2014 DAS 06 9-89
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									14-06-17 ME 14-6-17

Picklist Print

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Work Order ID: 116371

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS
per DS19414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

155

Each

290.0000

2

2

JUN 17 2014

AN526C1032R7

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

ST346

290

128831

8

M126175

32

M128403

250

AN526C832R8

Purchased

No

155

Each

351.0000

8

8

AN526C832R8

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

ST345

351

125388

14

m127817

87

m128403

250

AN526C832R9

Purchased

No

140

Each

668.0000

8

8

AN526C832R9

Screw

Location

Loc Qty

Loc Code

ST345

668

M127363

4

M128403

64

M128429

600

128429

DAS
28
9-89

DAS
31
9-89

DAS
28
9-89

DAS
31
9-89

DAS
33
9-89

14-06-03

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Work Order ID: 116371

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

D2143 Manufactured No 140 Each 22.0000 1 1

D2143

Hinge Bracket

DAS

33

9-89

Location

Loc Qty

Loc Code

ST005

22

100918

12

108818

7

98391

3

100918

D2144 Manufactured No 140 Each 21.0000 1 1

D2144

Hinge Doubler

DAS

33

9-89

14-06-03

Location

Loc Qty

Loc Code

ST005

21

100467

21

100467

D2150 Manufactured No 155 Each 16.0000 2 2

D2150

Packer Doubler, Hinge

DAS

28

9-89

JUN 17 2014

Location

Loc Qty

Loc Code

ST005

16

112962

16

106861

D2151 Manufactured No 155 Each 34.0000 2 2

D2151

Packer Doubler

DAS

28

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST005

34

102125

2

106821

32

114304

DAS
06
9-89

DAS

31

9-89

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Work Order ID: 116371

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

D2153

Manufactured No

155

Each

60.0000

1

D2153

Door Prop

**

DAS
28
9-89

JUN 17 2014

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

4

85865

4

ST260

56

100934

5

110755

18

114286

33

D2154

Manufactured No

155

Each

11.0000

1

D2154

Bracket, Stud

**

DAS
28
9-89

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST006

11

100839

11

D2237

Manufactured No

155

Each

60.0000

2

D2237

Striker Plate

**

DAS
28
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST007

60

108708

20

112911

40

D2445P

Purchased No

110

Each

0.0000

1

D2445P

Aft Door Assembly

**

DAS
28
9-89

DAS
31
9-89

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Work Order ID: 116371

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

D2461

Manufactured No

155 f

674.9700 7.25 8

D2461

Seal(Per Foot)

DAS
06
9-89

Location

Loc Qty

Loc Code

ST402

674.97

102517

174.97

114238

500

**

DAS
28
9-89

JUN 17 2014

DAS
31
9-89

(D2461-0870) cut (1) at 87.00"

**** per kit****

D2463

Manufactured No

140 f

341.6337 7.25 8

D2463

1/2" Seal (\$Per Foot)

**

DAS
33
9-89

Location

Loc Qty

Loc Code

ST402

341.633684

110718

341.633684

110718

(D2463-0870) cut (1) at 87.00"

**** per kit****

D2585

Manufactured No

140 Each

65.0000 2 2

D2585

Latch Clamp

**

DAS
33
9-89

14-06-03

Location

Loc Qty

Loc Code

ST012

65

108520

1

110344

3

112571

19

112974

14

114114

28

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Work Order ID: 116371

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

D2586

Manufactured No

140

Each

47.0000

2

2

D2586

Door Latch

**

114985

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

13

100607

2

83893

10

95760

1

ST198A

34

108573

24

113641

10

D2589

Manufactured No

155

Each

21.0000

1

1

D2589

Keys, Key Chain

DAS

06

9-89

**

DAS

28

9-89

JUN 17 2014

Location

Loc Qty

Loc Code

ST012

21

58194

21

D2621

Manufactured No

140

Each

48.0000

2

2

D2621

Latch Plate

**

DAS

33

9-89

1406-03

Location

Loc Qty

Loc Code

FG

2

88616

2

ST013

46

108138

3

115195

43

115195

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Work Order ID: 116371

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

D2690-17

Manufactured No

155

Each

33.0000

1

D2690-17

Cable

**

DAS
28
9-89

JUN 17 2014

DAS
06
9-89

Location

Loc Qty

Loc Code

ST016

33

100752

3

108397

5

110028

6

112206

6

114912

12

94470

1

IX

DAS
31
9-89

D2857-1

Manufactured No

140

Each

44.0000

1

1

D2857-1

Hinge Bracket

**

DAS
33
9-89

14-06-03

Location

Loc Qty

Loc Code

FG

5

82261

4

91914

1

ST019

39

106185

3

110247

12

113744

24

113744

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Page 7

Work Order ID: 116371

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

D2857-2

Manufactured No

140

Each

52.0000

1

1

D2857-2

Hinge Bracket

DAS
33
9-89

14-06-03

Location

Loc Qty

Loc Code

FG

3

78904

3

ST019

25

100769

1

108401

24

ST024

24

114154

24

108401

D2858-1

Manufactured No

155

Each

46.0000

1

1

D2858-1

Hinge Bracket

DAS
28
9-89

JUN 17 2014

Location

Loc Qty

Loc Code

FG

2

77019

2

ST019

44

100756

8

110032

12

114144

24

IX

DAS
31
9-89

D2858-2

Manufactured No

155

Each

44.0000

1

1

D2858-2

Hinge Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

2

77020

2

ST020

42

105555

18

113735

24

IX

DAS
31
9-89

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Work Order ID: 116371

116371

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

FG-778150-550-ROL

Purchased

No

155

sf

2,378.000

1

FG-778150-550-ROL

7781-96Z Glass 50x125yd

DAS
06
9-89

Location

Loc Qty

Loc Code

CA

2378

M127570

815

M127701

1563

**

DAS
28
9-89

JUN 17 2014

DAS
31
9-89

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased

No

155

Each

7,961.000

12

MS20426AD3-4

RIVET

DAS
06
9-89

Location

Loc Qty

Loc Code

MF4

365

125578

365

ST334

3192

m127432

3192

ST509

4404

125578

4404

**

DAS
28
9-89

DAS
31
9-89

MS20470AD4-5

Purchased

No

155

Each

4,029.000

18

MS20470AD4-5

RIVET, UNIVERSAL HEAD

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

7

m126926

7

ST336

4022

m126926

716

m128401

1653

m128813

1653

**

DAS
28
9-89

DAS
31
9-89

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Shop Packet Print

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Work Order ID: 116371

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

140

Each

6,190.000

8

8

MS21042L08

Nut

**

DAS

33

9-89

14-06-03

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2533

125445

1135

m127410

1398

ST509

99

m127304

99

128429

MS21042L08

Purchased

No

155

Each

6,190.000

10

10

MS21042L08

Nut

**

DAS

25

9-89

JUN 17 2014

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2533

125445

1135

m127410

1398

ST509

99

m127304

99

128429

DAS

31

9-89

DAS

06

9-89

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Work Order ID: 116371

116371

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140

Each

8,800.000

2

2

DAS

MS21042L3

Nut

**

33

9-89

14-06-03

Location

Loc Qty

Loc Code

ST314

1845

M127410

804

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

128754

MS21042L3

Purchased

No

155

Each

8,800.000

4

MS21042L3

Nut

**

DAS

28

9-89

JUN 17 2014

Location

Loc Qty

Loc Code

ST314

1845

M127410

804

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

4x

DAS

31

9-89

DAS

31

9-89

Picklist Print

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Work Order ID: 116371

116371

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11

Purchased

No

155

Each

544.0000

2

2

DAS
28
9-89

JUN 17 2014

MS27039-08-11
SCREW

**

Location

Loc Qty

Loc Code

ST307

18

123352

18

ST506

526

122441

37

123185

1

123900

88

M128770

400

2x

DAS
31
9-89

MS27039-1-15

Purchased

No

140

Each

1,027.000

2

2

DAS
33
9-89

MS27039-1-15

Screw

**

Location

Loc Qty

Loc Code

ST306

427

124326

427

ST506

600

m127916

600

124326

NAS1149D0363J

Purchased

No

140

Each

5,383.000

2

2

DAS
33
9-89

NAS1149D0363J

Washer

**

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

5360

m126319

130

m127813

230

m128429

5000

128429

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Work Order ID: 116371

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

155

Each

5,383.000

2

2

NAS1149D0363J

Washer

**

DAS

28

9-89

JUN 17 2014

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

5360

m126319

130

m127813

230

m128429

5000

140

Each

2,506.000

8

8

NAS1149DN832J

Purchased

No

NAS1149DN832J

Washer

**

DAS

33

9-89

128948

14-06-03

Location

Loc Qty

Loc Code

MF4

912

M127255

912

ST293

1432

M127813

432

M128429

1000

st510

145

124555

145

ST510a

17

M126319

17

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

155

Each

2,506.000

16

16

NAS1149DN832J

Washer

DAS

**

SS

9-89

14-06-03

DAS
06
9-89

Location

Loc Qty

Loc Code

MF4	912
M127255	912
ST293	1432
M127813	432
M128429	1000
st510	145
124555	145
ST510a	17
M126319	17

128948

DAS
28
9-89

JUN 17 2014

DAS
31
9-89

DAS
06
9-89

D5080-041 2X Bt 179725

DAS
31
9-89

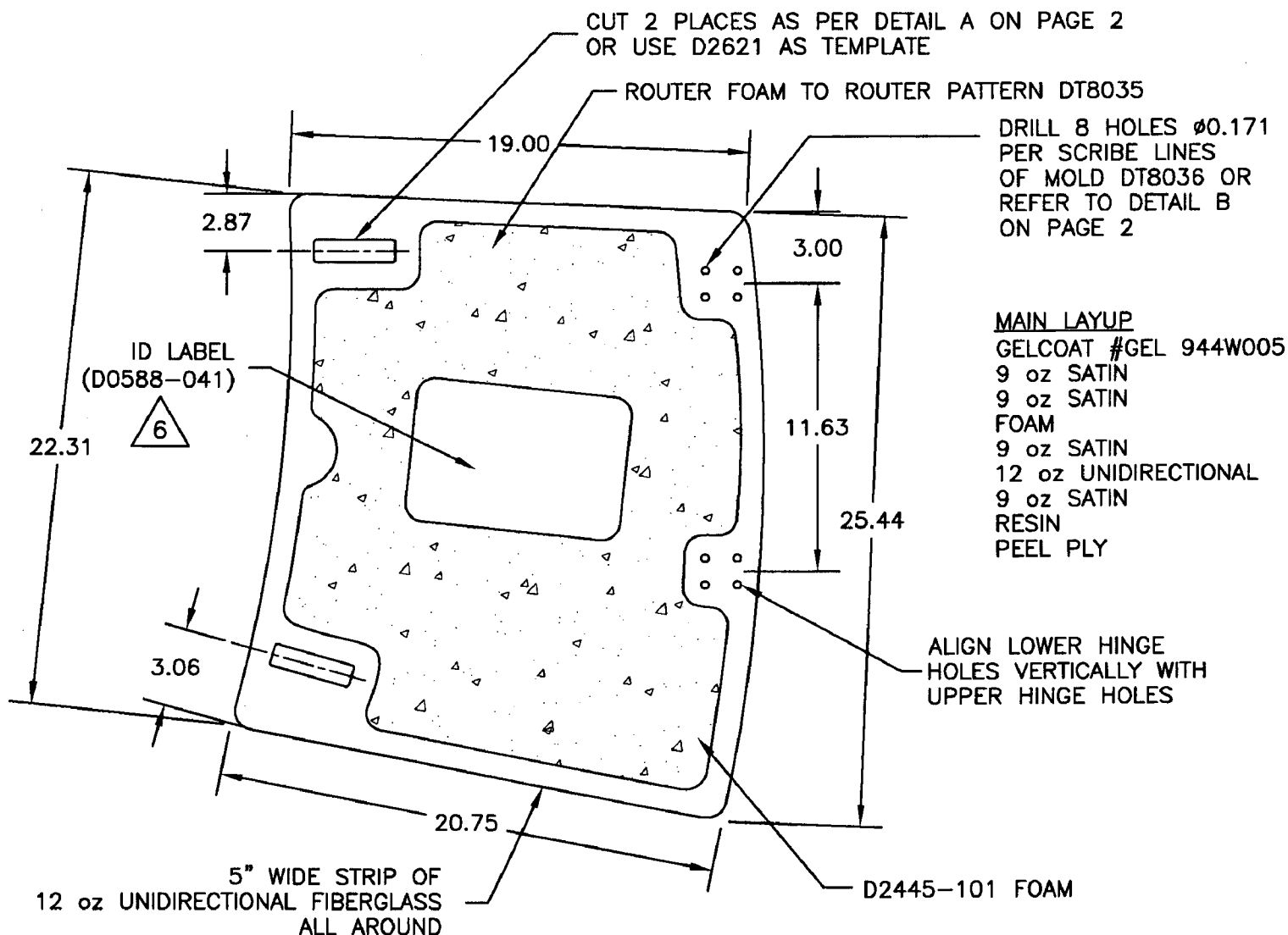
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DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DMVYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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02/11/04/14
W/O: 116371

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

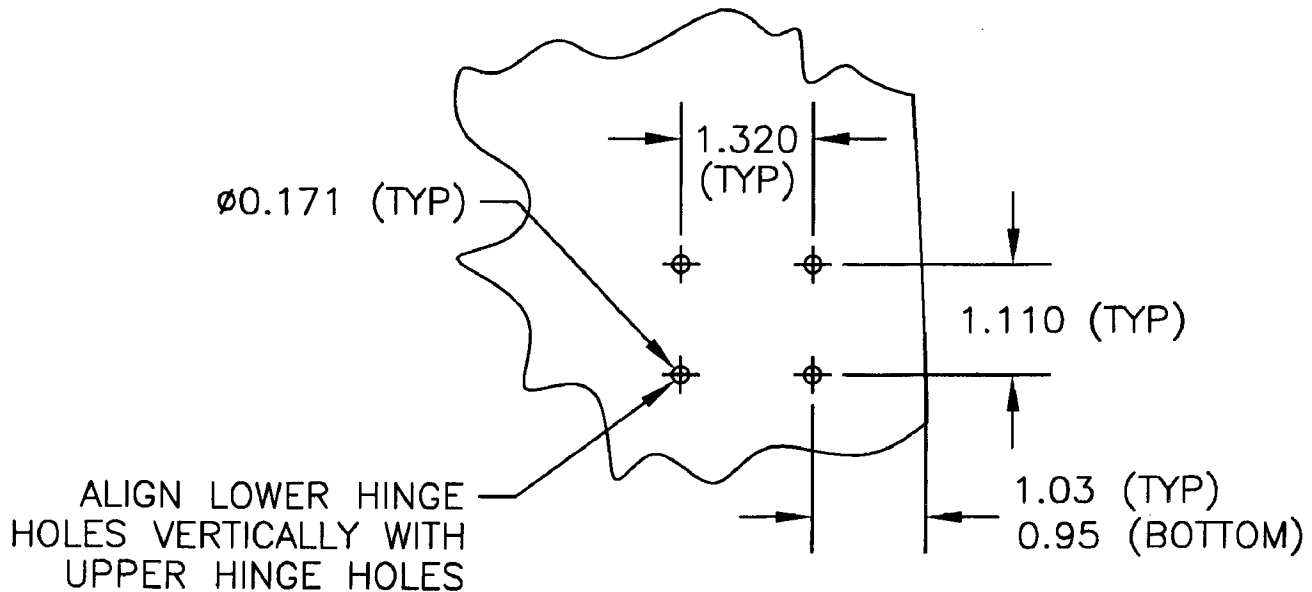
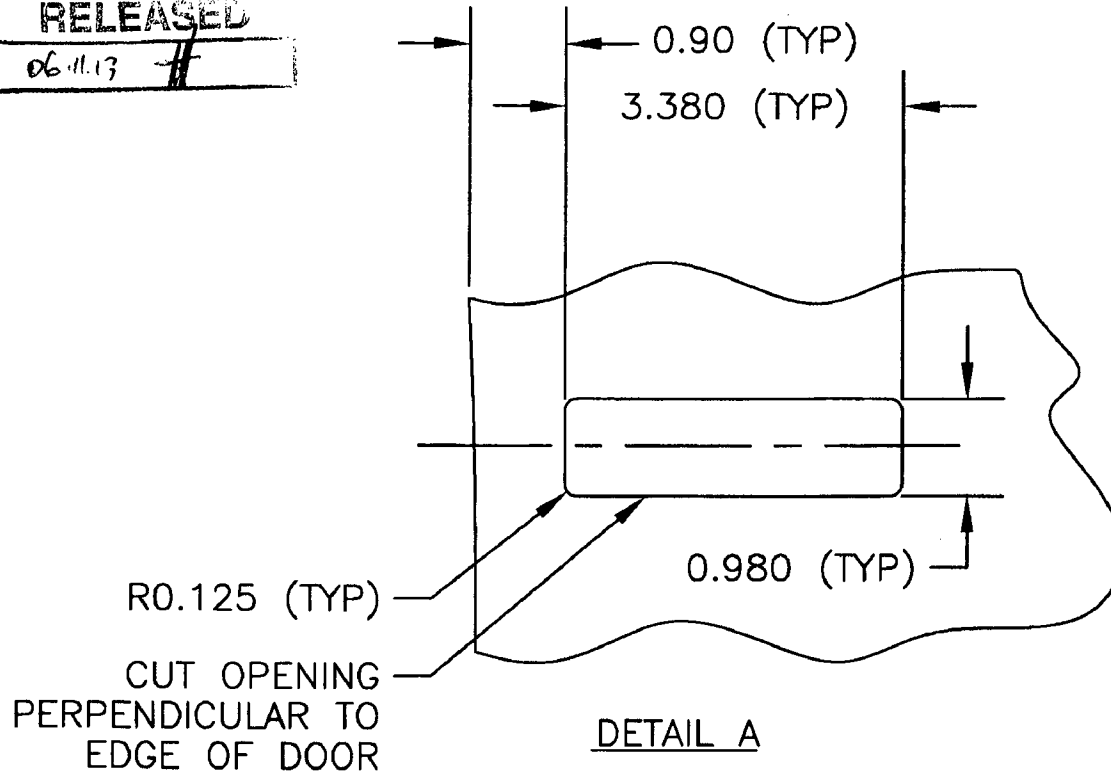
FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED

06.11.13 *[Signature]*



DETAIL B

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
--	--	---	---

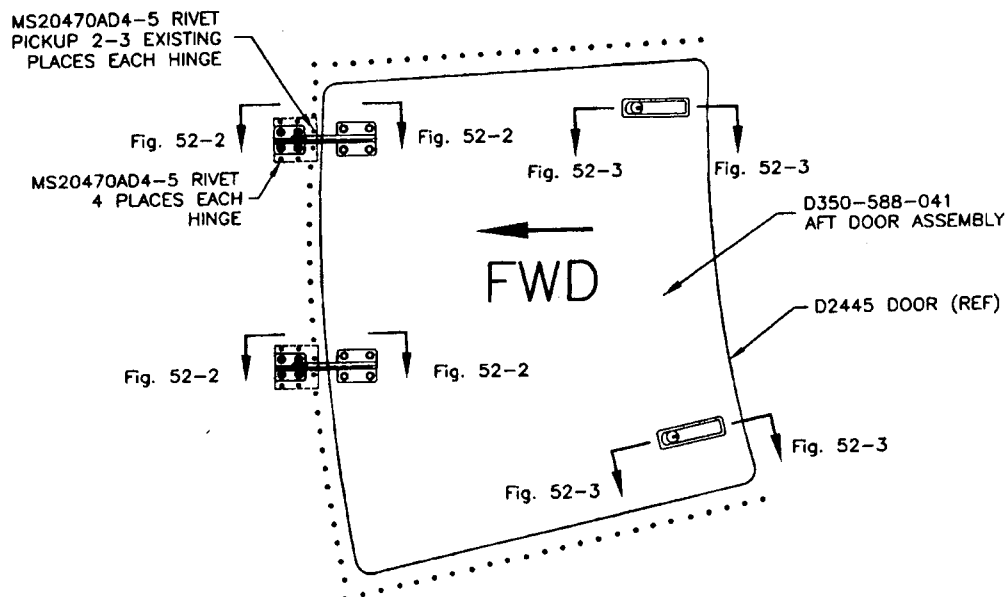


Figure 52-1: Baggage Door Outside View

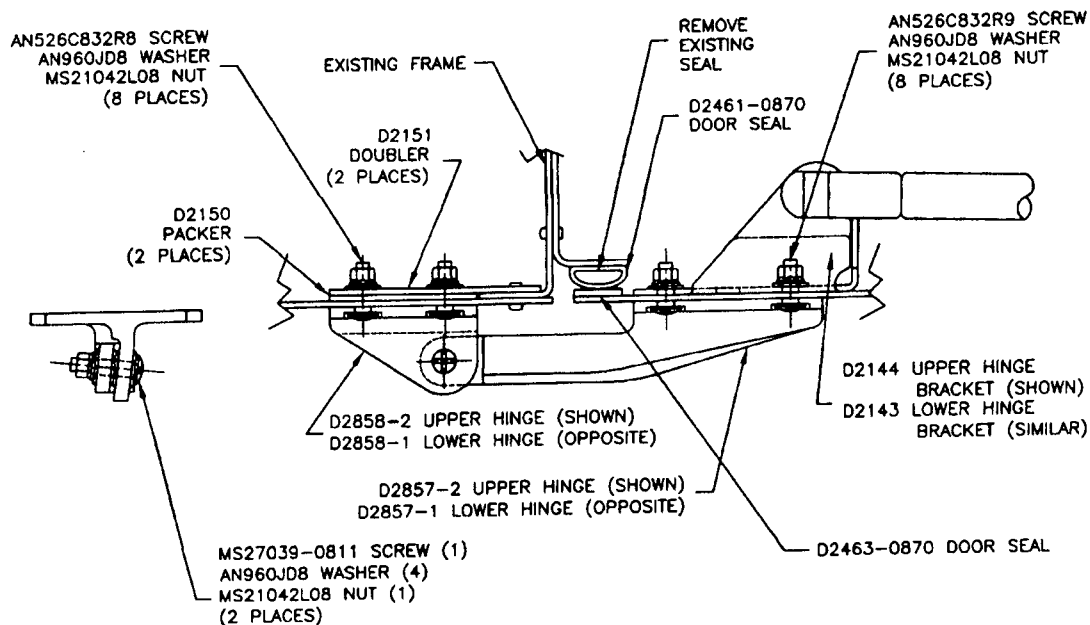


Figure 52-2: Hinge Detail

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52-00-00

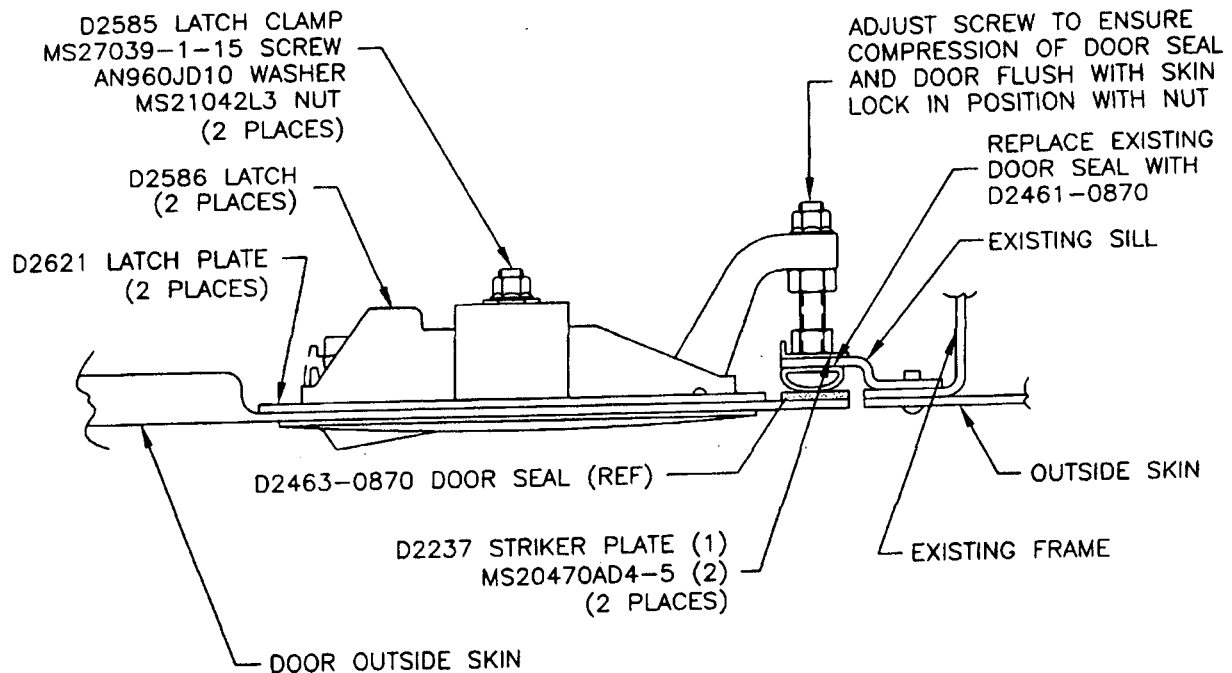


Figure 52-3: Latch Section

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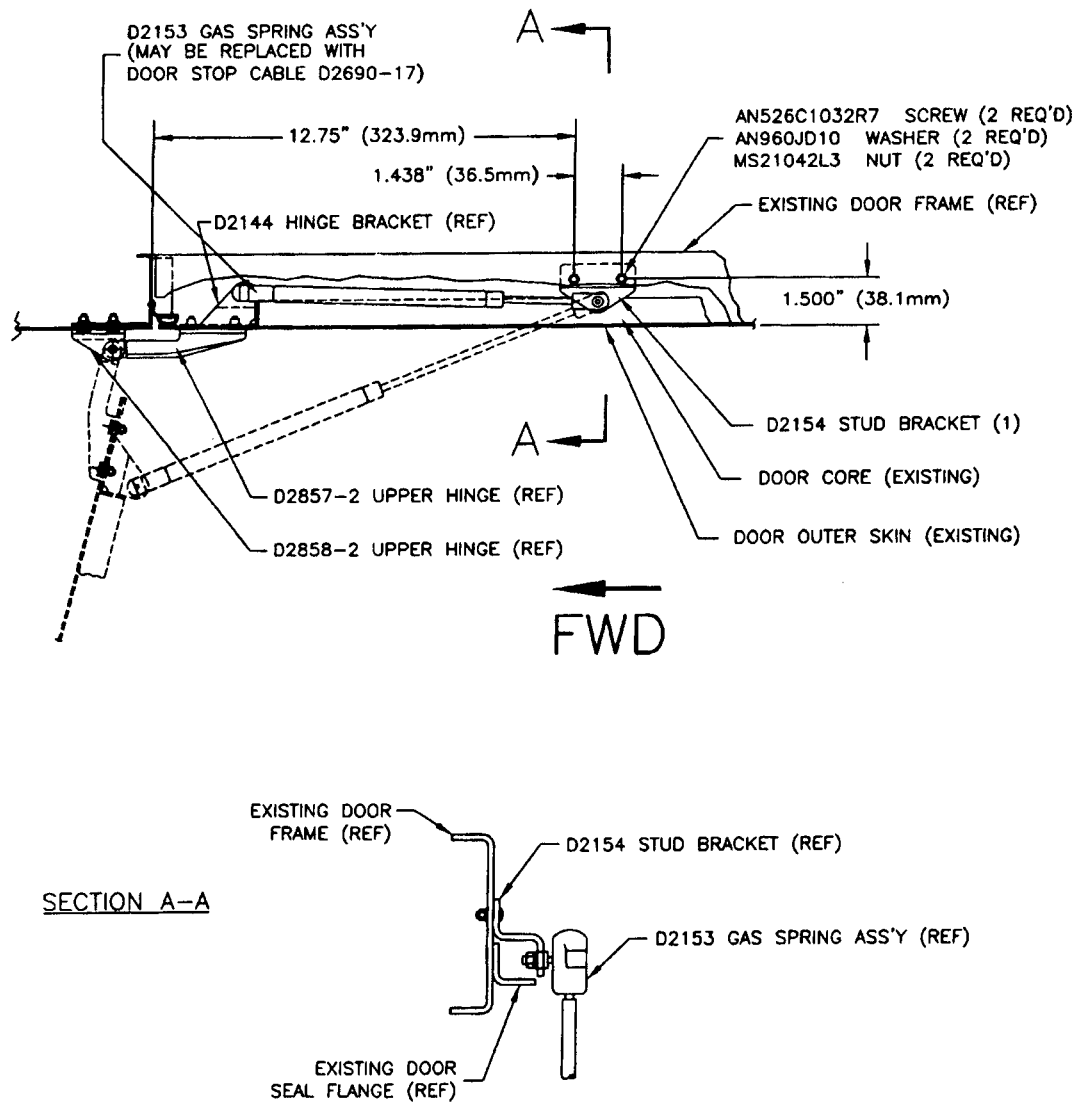


Figure 52-4: Gas Spring Installation

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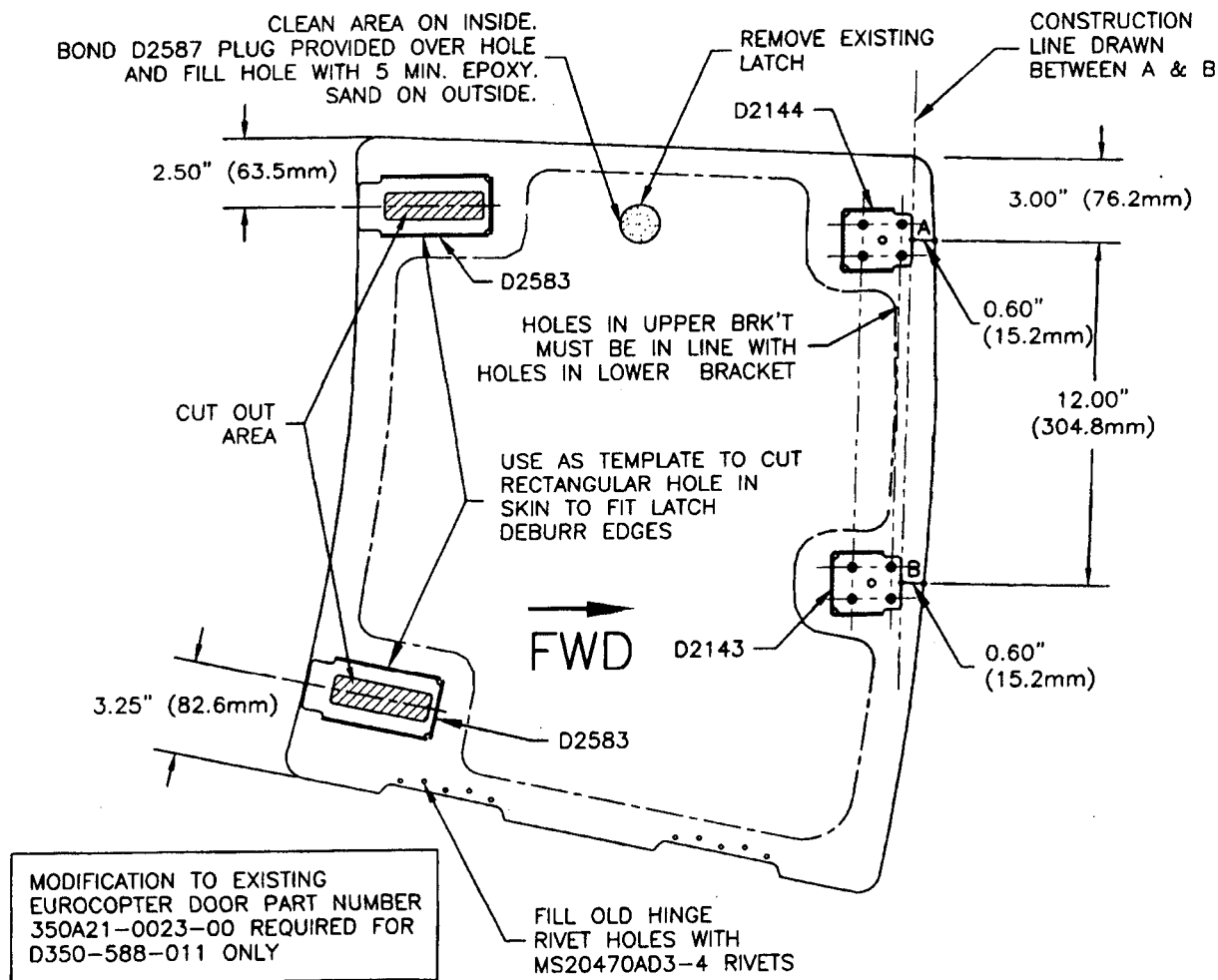


Figure 52-5: Baggage Door Inside View

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52-00-00

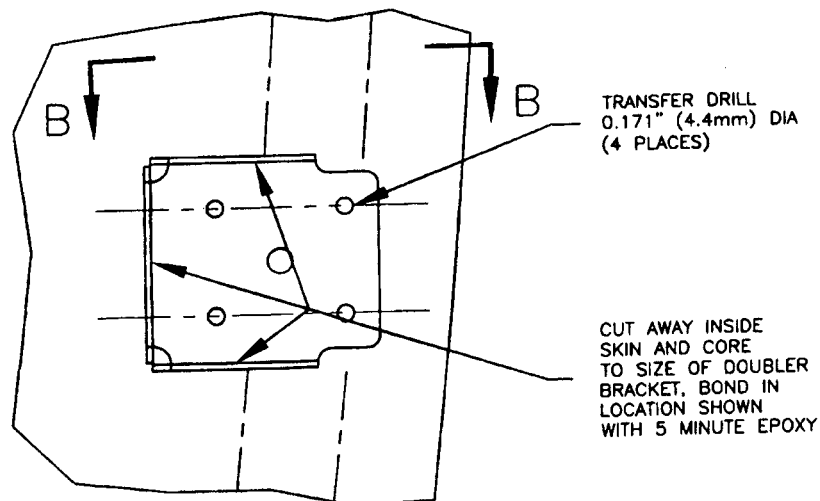
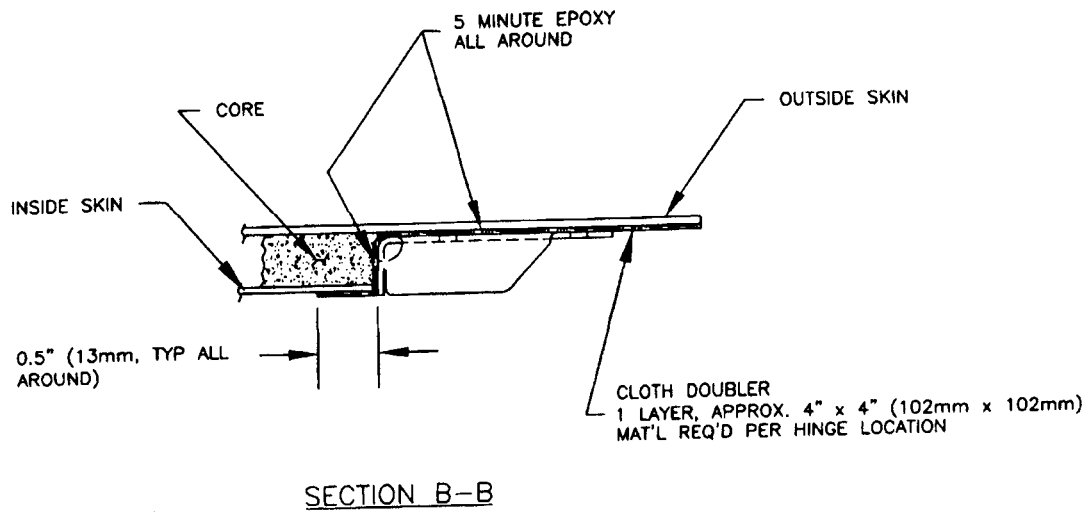


Figure 52-6: Typical Doubler Bracket Installation

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52-00-00



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23807

Purchase Order Date 4/15/2014

PO Print Date 4/15/2014

Page Number 2 of 3

Order From :

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 819 533 5788

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

FCA - (Free Carrier)

Line Total:

\$59

4 D2445P

Aft Door Assembly

5/30/2014

Yes

5/30/2014

1.00
Each

\$592.76

\$59

AS PER DWG D2445 REV. D
B116370

1-14/0126

Line Total:

\$59

5 D2445P

Aft Door Assembly

6/10/2014

Yes

6/10/2014

1.00
Each

\$592.76

\$59

AS PER DWG D2445 REV. D
B116371

Line Total:

\$59

6 D2445P

Aft Door Assembly

6/10/2014

Yes

6/10/2014

1.00
Each

\$592.76

\$59

AS PER DWG D2445 REV. D
B116372

8014-6-2

Note:

4/15/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	57445
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
30-05-2014	15-04-2014	24538	Chantal Lavoie	PO23807	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
FEDEX P1 Collect	Point de départ	Jocelyne Laurin, 221			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0013	Line #5 Aft Baggage Door (D2445) B116371 U of M: Chaq Drawing N° : D2445 Rév.: D	
				DOCUMENT INCLUS	
				Serial #	Lot #
				B116371	61089
1	0	1	DKC134-0013	Line #6 Aft Baggage Door (D2445) B116372 U of M: Chaq Drawing N° : D2445 Rév.: D	
				Serial #	Lot #
				B116372	61087

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Quality department

AQ-35

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mercredi, 2014-04-16 08:14:00
 Utilisateur: marc dubé

Feuille de Procédé

4/3 mai

Client :	DART US DART AEROSPACE	Nom Dessin :	N° D2445, AFT BAGGAGE DOOR
Numéro Job :	61089	Numéro Article :	DKC134-0013
Numéro :	3959	Numéro Dessin :	D2445
Numéro B.A. :		Projet Numéro :	DK-362
Cette fois :	2014-04-16 No. :	Révision dessin :	D
Prsht Rev. :	NC	Matériel :	Composite
Prem. fois :	-- Type :	Date Dûe :	2014-06-10
Job précédente :	55240	Qté:	1 Ud UNITE

Écrit par : _____
Vérifié & Approuvé par : _____
Commentaires : N° de pièce Client: N/A



B116371

COPIE

E.O.: N/A

Feuille de Procédé Rév.: 05 ajout de l'IF134-0007 sur plusieurs séquences, numéro du moule passe de DT-8036 pour DKO-0235, numéro du moule passe de DT-8619 pour DKO-0063, ajouter IF134-0006 pour le taillage

Formulaire d'inspection: N/A

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

Comment	Qty.: 0.200 UNITE(s)/Unit	Total : 0.200 UNITE(s)
	N° 83634, Frekote Loctite Wolo	# de Lot: 1-42289-1

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DKO-0235 selon IG 0009.

Date: 5/05/14



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Comment	Qty.: 0.200 KILOGRAMME(s)/Unit	Total : 0.200 KILOGRAMME(s)
	Gel Coat Blanc N° Gel 944W005	N° de Lot: 1-45003-2

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Comment	Qty.: 0.0320 GALLON(s)/Unit	Total : 0.0320 GALLON(s)
	Catalyst N° DDM-9	N° de Lot: 1-22829-1

Date: Mercredi, 2014-04-16 08:14:00
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61089

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

5.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 5/05/14 Sceau:



6.0 GEL COAT Application du Gel Coat



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IF134-0007

Date: 5/05/14 Sceau:



7.0 AAC1885 Tissu à délaminer Release ply B

Comment Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)
Tissu à délaminer Release ply B # de Lot: N/A

8.0 AAC1887 Wrightlon 5200 Bleu P3

Comment Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)
Wrightlon 5200 Bleu P3 # de Lot: N/A

9.0 AC0885 Feutre de drainage N° Airweave N 10

Comment Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

10.0 AC0943 Stretchlon 200 poche à vide Vert

Comment Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

11.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 2.00 VERGE(s)/Unit Total : 2.00 VERGE(s)
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-44353-3

12.0 AMB0511 N° TG-13-U, Fiberglass 13 oz

Comment Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)
N° TG-13-U, Fiberglass 13 oz

N° de Lot: 1-36302-1

13.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

14.0 PREP-GENERAL Préparation du matériel

















Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Découper les tissus selon IF134-0007.

Information de référence pour les tissus::













Date: Mercredi, 2014-04-16 08:14:00
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	61089	Numéro	DKC134-0013
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	4 plis de tissus de 9.7 oz. 1 pli de 13 oz. pour tout le contour de la pièce par 5" de large. 3 fois le sac à vide Strechlon 200. 3 fois le film perforé P-3 3 fois le feutre de drainage 2 fois le tissu à délaminer (non nécessaire lors du bagging du core). Date: <u>12/04/14</u> Sceau: 		
15.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0130 GALLON(s)/Unit Total : 0.0130 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
16.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-43606-1</u>		
17.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350 Date: <u>5/05/14</u> Sceau:  		
18.0	LAMINAGE	Faire le laminage	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Laminer la pièce selon IF134-0007. Date: <u>5/05/14</u> Sceau:  		
19.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012. Laisser sécher pendant 4 heures minimum. Heure Curing début: <u>2:50</u> Heure Curing Fin: <u>8:00</u> Date: <u>5/05/14</u> Sceau:  		

















Date: Mercredi, 2014-04-16 08:14:00
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61089	Numéro DKC134-0013	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
20.0	AMB0286	Catalyst N° DDM-9
Comment Qty.: 0.0042 GALLON(s)/Unit Total : 0.0042 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-97829-1</u>		
21.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-45003-1</u>		
22.0	PREP-GENERAL	Préparation du matériel
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105. Date: <u>06/05/14</u> Sceau: 		
23.0	AAC1611	Polybond B46F
Comment Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s) Polybond B46F N° de Lot: <u>1-38789-1</u>		
24.0	DKC134-0029	Foam Core N° D2445-101 (Pour AFT Baggage Door)
Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: <u>61096</u>		
25.0	ASSEMBLAGE	Assemblage mécanique
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Coller le Foamcore selon IF134-0007. Date: <u>6/05/14</u> Sceau:  		
26.0	BAGGING	Faire le bagging sur la pièce
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012 Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond. Heure début Curing: <u>9:40</u> Heure Fin Curing: <u>10:50</u> Date: <u>6/05/14</u> sceau:  		















Date: Mercredi, 2014-04-16 08:14:00
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61089	Numéro: DKC134-0013	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
27.0	AMB0286	Catalyst N° DDM-9
Comment Qty.: 0.1360 GALLON(s)/Unit Total : 0.1360 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
28.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-45606-1</u>		
29.0	PREP-GENERAL	Préparation du matériel
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350. Date: <u>07-05-14</u> Sceau:  		
30.0	LAMINAGE	Faire le laminage
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le laminage des tissus de verre selon IF134-0007. Date: <u>07-05-14</u> Sceau:  		
31.0	BAGGING	Faire le bagging sur la pièce
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012 Laisser sécher pendant 4 heures minimum. Heure Curing Début: <u>8:45</u> Heure Curing Fin: <u>8:00</u> Date: <u>07-05-14</u> Sceau:  		
32.0	DÉMOULAGE	Démoulage de la pièce
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Démouler la pièce en faisant bien attention aux coins & rebords. Date: <u>8/05/14</u> Sceau: 		

Date: Mercredi, 2014-04-16 08:14:00
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61089		Numéro DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
33.0	TRIMAGE	Trimage	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Tailler la pièce selon IF134-0006.			
Date: <u>8/05/14</u> Sceau:  			
34.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)			
N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-45373-1</u>			
35.0	FINITION	Finition Générale	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.			
Date: <u>8/05/14</u> Sceau:  			
36.0	AAC1021	Dupont Primer N° 7704S	
Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)			
Dupont Primer N° 7704S N° de Lot: <u>1-54556-3</u>			
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)			
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-44063-3</u>			
38.0	PRIMER	Application primer	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la préparation et l'application du primer batisseur selon I.G. 0008			
Date: <u>12/05/14</u> Sceau: <u>5, D 4400</u> # de fiche de mélange: <u>6598</u>			
39.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)			
N° P-15-3, Adtech Micro Ultra Filler # de Lot: _____			
40.0	FINITION	Finition Générale	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.			
Date: <u>13-05-14</u> Sceau: 			

Date: Mercredi, 2014-04-16 08:14:00
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61089

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

41.0 AAC1605 Label N° D0588-041

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Label N° D0588-041 N° de Lot: 1-45570-1

42.0 AAC1609 Surface Veil

Comment Qty.: 0.07 VERGE(s)/Unit Total: 0.07 VERGE(s)
Surface Veil N° de Lot: 1-44695-1

43.0 AAC1220 Résine Mia-Poxy 100

Comment Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s)
Résine Mia-Poxy 100 N° de Lot: 1-36095-4

44.0 AAC1221 Durcisseur 95 Pour Résine Mia-Poxy

Comment Qty.: 0.007 QUART(s)/Unit Total: 0.007 QUART(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: 1-34505-1

45.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Coller le label N° D0588-041 selon IG 0111.

Date: 13-05-14 Sceau:

46.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-43798-2

47.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44063-3

48.0 PRIMER Application primer



+1 Rework Date

20/05/14



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

AQ16:6604



Faire la préparation et l'application du primer final selon I.G. 0008

Date: 15/05/14 Sceau: # de fiche de mélange: 6602

49.0 INSPEC FINAL Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: 22/05/14 Sceau:

Date: Mercredi, 2014-04-16 08:14:00

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 61089

Numéro DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

50.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Date: 23 MAI 2014

Sceau:



3.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-08-17	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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Revision: D

Date: 02.01.17

3.0 PARTS LIST:

The part lists of D350-588 Rev. D and ICA-D350-588 Rev. 0 are amended as follows.

IS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D5080-041	STRIKER PLATE ASSY (AS355 N/NP MODELS ONLY)
2	2	D2237	STRIKER PLATE

WAS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D2237	STRIKER PLATE

Customers who need to upgrade a D350-588-011/-041 kit that has been previously purchased from Dart can procure the DSI 9690-011 Kit from Dart.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9690-011	STRIKER PLATE MODIFICATION KIT
2	D5080-041	STRIKER PLATE ASSEMBLY

4.0 WEIGHT AND BALANCE:

This DSI has a negligible effect on Weight and Balance of the aircraft.

5.0 MAINTENANCE:

Maintain the D5080-041 Striker Plates in accordance with the procedures for the D2237 Striker Plates as outlined in ICA-D350-588.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH92-41
ISSUE NO.: 8

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9690	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STRIKER PLATE MOD	NTS
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